

Date: Monday, 8/13/2007 3:45:19 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 33882		
Estimate Number	: 10224		
P.O. Number	: <i>N/A</i>	Part Number	: D2143
This Issue	: 8/13/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2143 REV. C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: C1
Previous Run	: 31781	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i> 07-08-13	Due Date	: 8/20/2007 Qty: 50 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est C 00.05.18 Added inspection level 8 EC Est Rev:D Now on WaterJet 06-10-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0693 sf(s)/Unit Total : 3.4650 sf(s)
 Material: 5052-H32 (QQ-A-250/8) 0.040" thick
 (M5052H32S.040) Batch: *M104921 B07-08-14*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2143
 Dwg Rev: *CI*
 Prog Rev: *CI*

*B07-08-14**(52)**(P10)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B07-08-14

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*57/08/14 (52)**counted*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

*Deburr → SAG 07/08/14**52 counted*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 33882

Part Number: D2143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2143

SB 07/08/200

(52)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/20

(52) (52)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ

07-08-24

(50)

9.0

POWDER COATING

POWDER COATING



M105068



(50X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L

07/08/28

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/8/29 59

(50X) Le

(50X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST210

10 7/8/29 (50)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/30

Job Completion

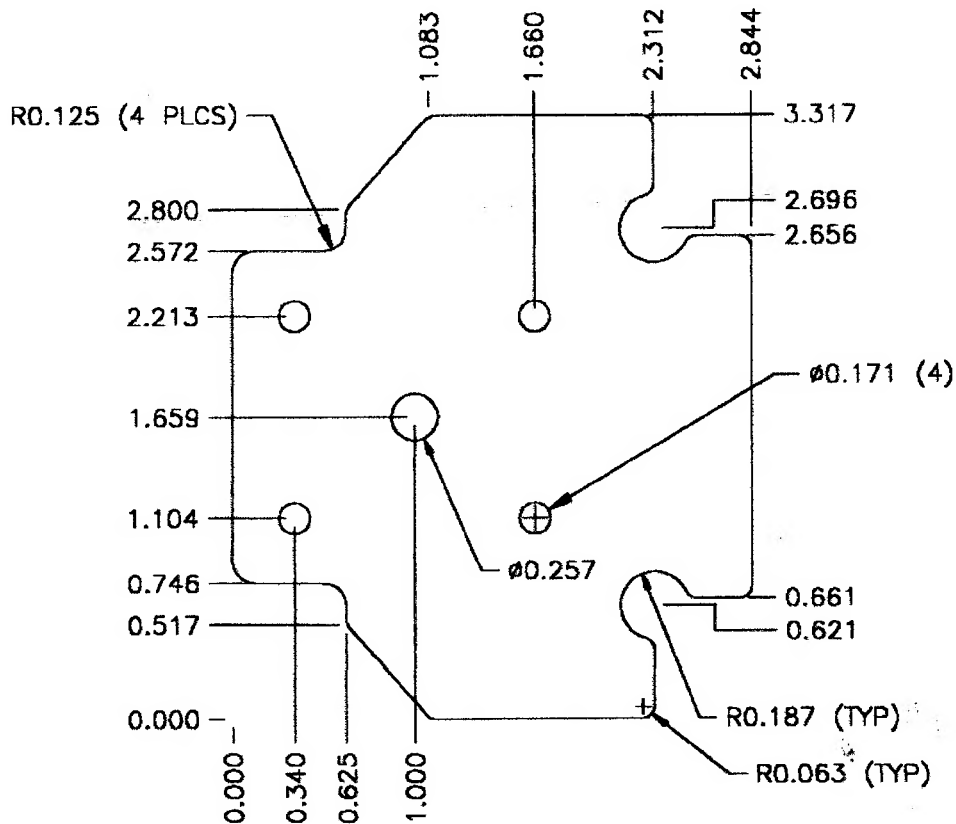


U 07-08-30



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
J BRADLEY	K HAND	DRAWING NO.	REV. a
CHECKED	APPROVED	D2143	SHEET 2 OF 2
DATE		TITLE	SCALE
95:10:18		HINGE BRACKET FLAT PATTERN	1:1

RELEASED
96620 62

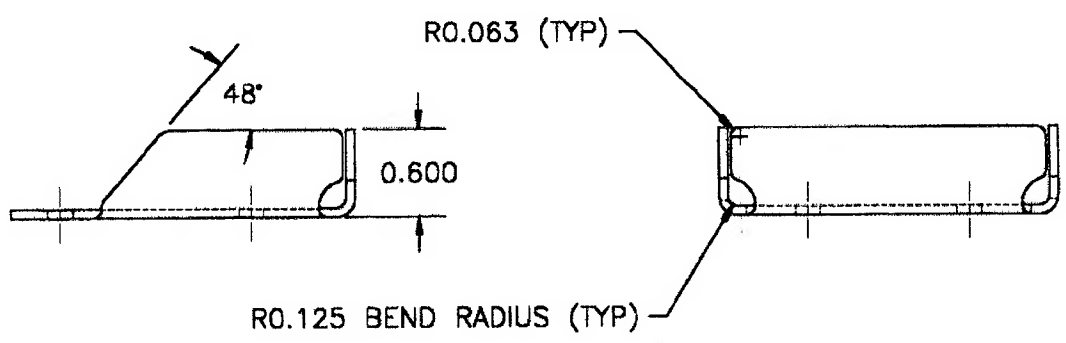
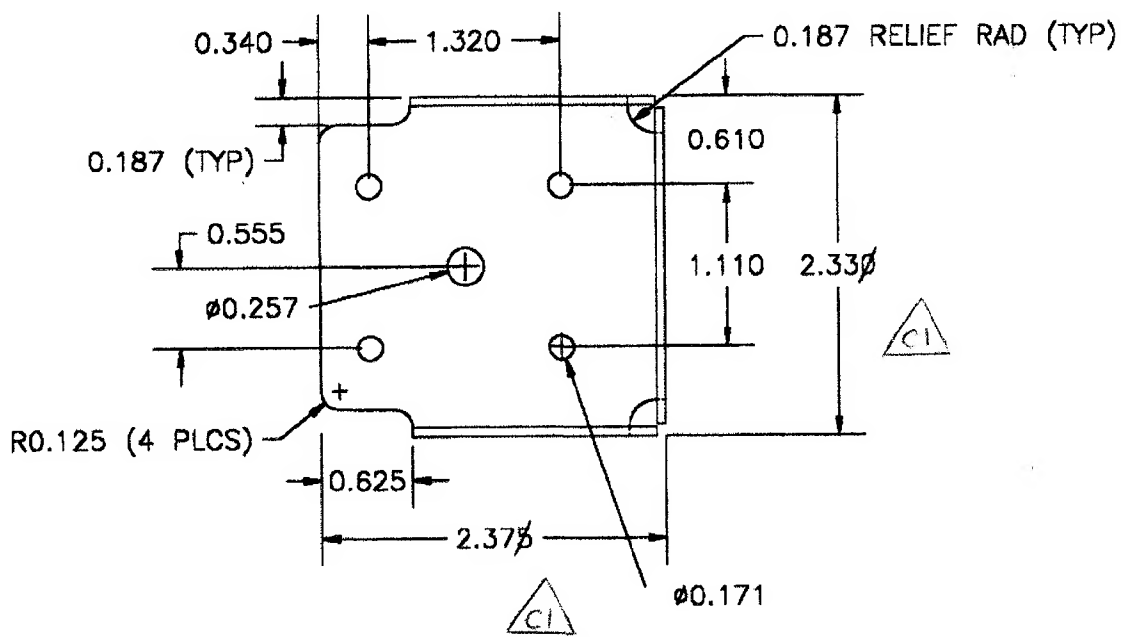


MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317



RELEASED
96.06.20 B.S.

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C
J BRADLEY	K HAND	DRAWING NO. D2143	SHEET 1 OF 2
CHECKED	APPROVED	TITLE	SCALE
B.S.	B.S.	HINGE BRACKET	
DATE			
92.07.10			
B	96.06.06	ADD FLAT PATTERN	
C	96.06.13	MATERIAL WAS 2024-T3 .063 THICK	
CI	04.06.15	UPDATE DIMENSIONS	



MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/14	21	Change grain direction on Drawing D2143 of 45° cut along 3.317				07/08/14	En 07/08/14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/130
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries